

Date: Friday, 16/05/2008 9:13:45 AM  
User: Linda Lacelle

# Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	INSTALL <del>D350-636-043</del> <i>W</i>
Job Number :	39189	Part Number :	D350636014
Estimate Number :	10804	Drawing Number :	D350-636-014
P.O. Number :		Project Number :	
This Issue :	16/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	
First Issue :	12/05/2008	Material :	
Previous Run :	38853	Due Date :	19/05/2008
Written By :	<i>[Signature]</i>	Qty:	1 Um: Each
Checked & Approved By :	<i>[Signature]</i>		
Comment :			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: Photocopy bluefile & type labels per PPP

CHG002 *[checkmark]*

*OLD 08.5.30*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



*(IX)*

Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D350-636-014 B *33142* CHG002

*M-L 08/05/29*

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



*(IX)*

Comment: HAND FINISHING RESOURCE #1

INSTALL STAINLESS STEEL WEARPLATES  
PER DRWG DSI9413 REV.A

*M-L 08/05/29*

4.0	D350636014	Skidtube RH
-----	------------	-------------



*(IX)*

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Skidtube LH

*M-L 08/05/29*

5.0	D35371	Wearpad
-----	--------	---------



*(IX)*

Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
WEARPAD  
batch *B 36426* *(2X)*

*B 36426* *(IX)*

*M-L 08/05/29*

Date: Friday, 16/05/2008 9:13:45 AM  
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## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 39189

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

batch

B38162

m-h

7.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

batch

B38565

m-h

8.0

D37941

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39279

m-h

9.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39277

m-h

10.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39276

m-h

11.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39361

m-h

12.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39278

m-h

13.0

D36721

Phenolic Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Phenolic Washer

B34470

m-h 05/05/09

(IX)

Date:  
User:

Friday, 16/05/2008 9:13:45 AM  
Linda Lacelle

B3918-9-  
Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: INSTALL D350-636-043

Job Number: 39189

Part Number: D350636014

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw

M108062

M-1

15.0

AN526C1032R18

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw

M108079

M-1

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT  
ORIGINAL KIT WITH TUBE

8/05/29 (42)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/05/29 (41)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
RE-PACKAGE PER PPP  
USING NEW B/N - CHG0001  
NEW LABELS REQ'D

Rev C

8/5/30

(X)

SP

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion

Part #



Quantity

Batch #

U 8-10-03

AN3C-SA

38

M107737

AN960C-10L

38

M108077

MS21083-C8

1

M107756

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

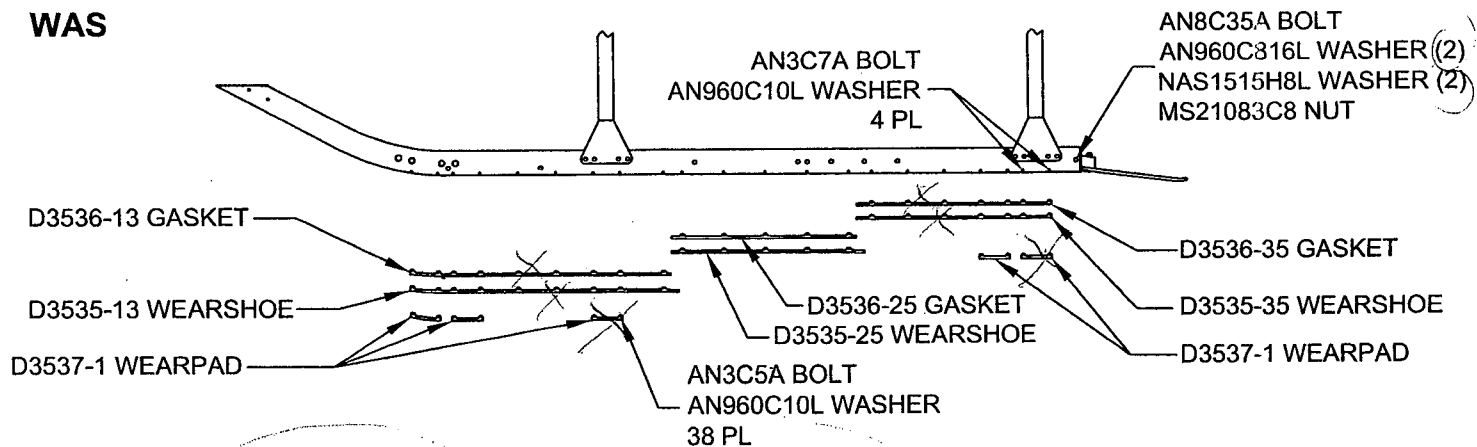
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

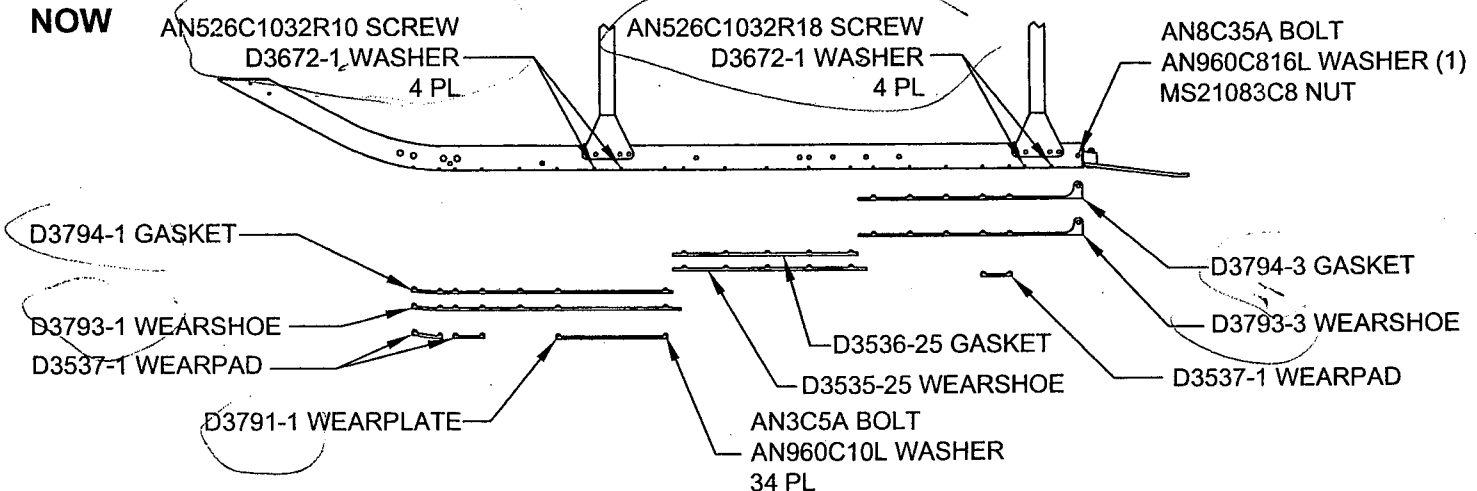
TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

**WAS**



**NOW**



**FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011**  
(LOCATION OF AN526C1032RXX SCREWS ARE NOT TO BE USED TO MOUNT WEARSHOES)

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED	J	DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**PRELIMINARY ISSUE**  
wb 39189

**DART****RELEASED**  
07-08-02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>HA</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS	
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 2 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b> SCALE NTS	

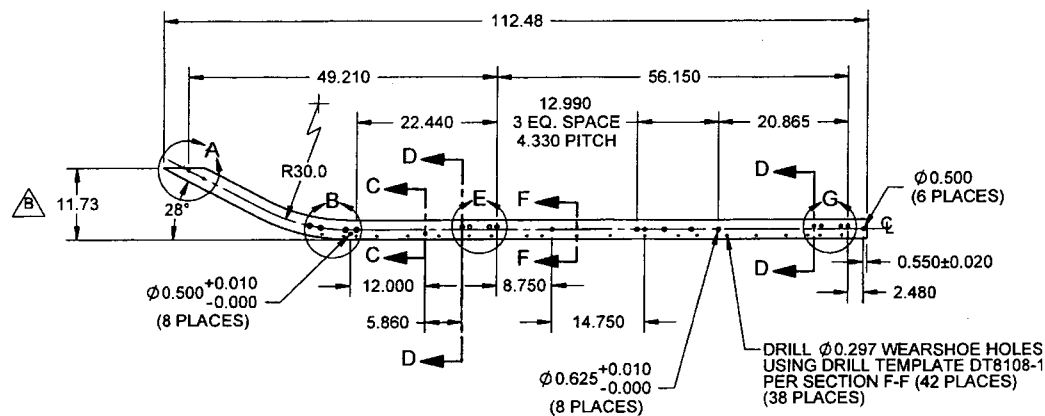
GENERAL NOTES:

**RELEASED**  
*07-08-02 [Signature]*

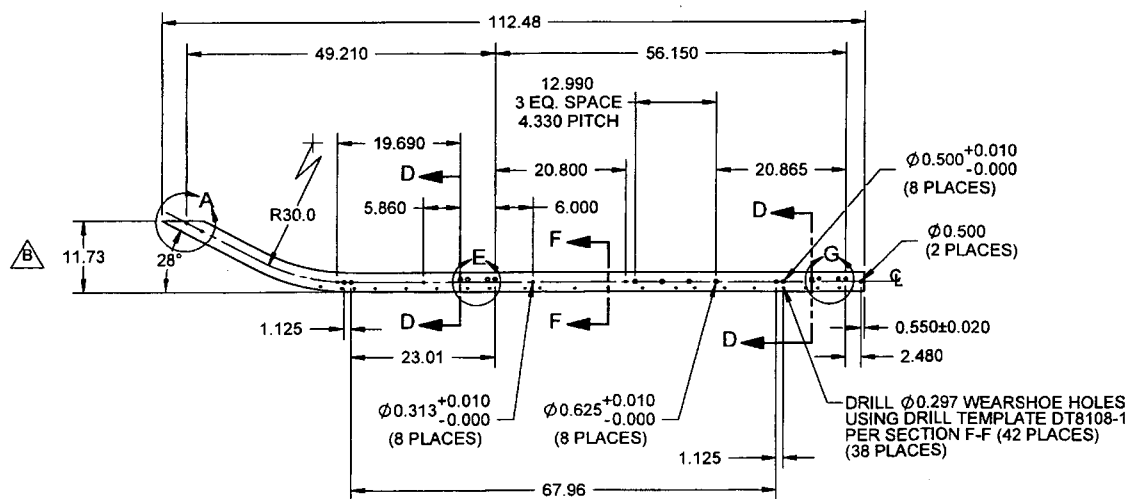
1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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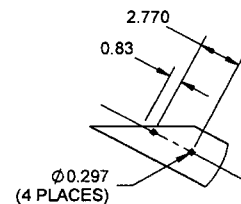
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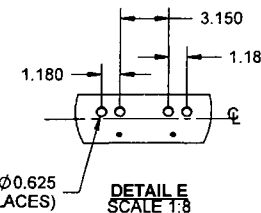
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



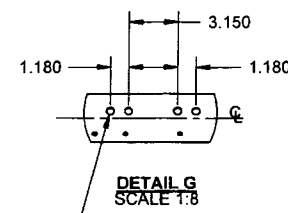
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



**DETAIL A**  
**SCALE 1:8**

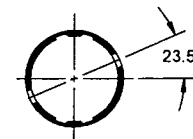


**DETAIL E**  
**SCALE 1:8**

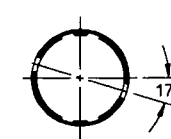


**DETAIL G**  
**SCALE 1:8**

$\phi 0.500^{+0.010}_{-0.000}$   
 (8 PLACES)

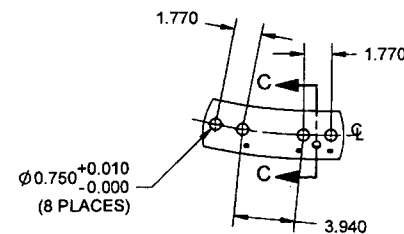


**SECTION C-C**  
**SCALE 1:4**

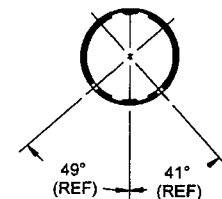


**SECTION D-D**  
**SCALE 1:4**

**RELEASED**  
 07-08-00

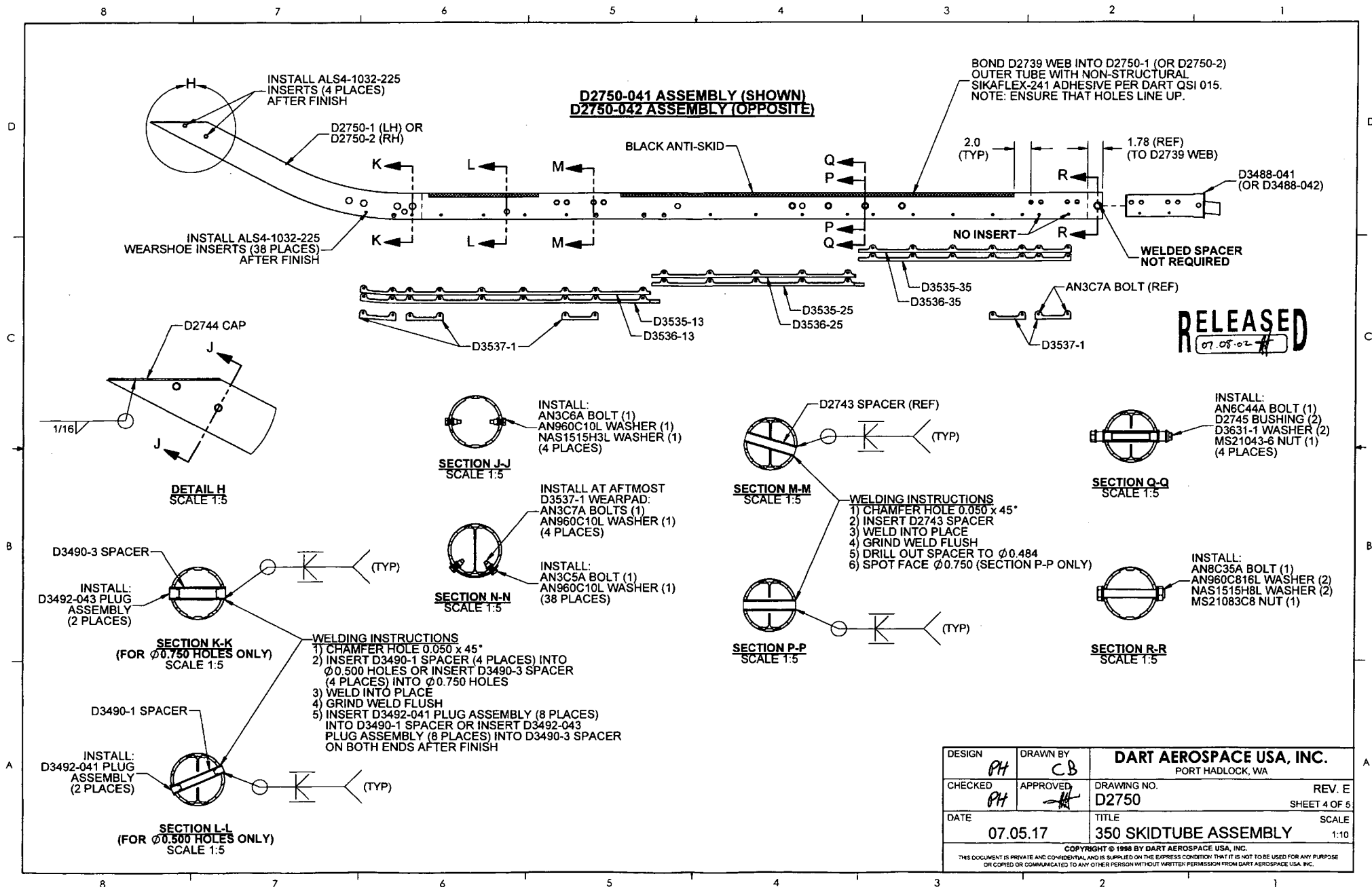


**DETAIL B**  
**SCALE 1:8**  
 (ALL DIMENSIONS ARE  
 STRAIGHT LINE DIMENSIONS)



**SECTION F-F**  
**SCALE 1:4**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 3 OF 5
DATE <b>07.05.17</b>	TITLE <b>350 SKIDTUBE ASSEMBLY</b>		SCALE 1:20
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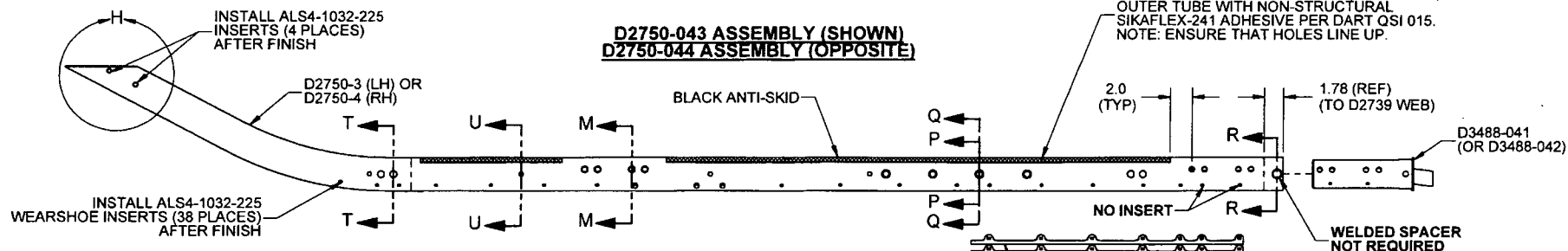




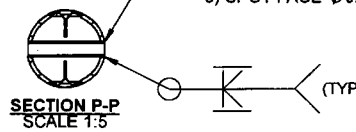
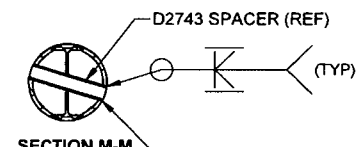
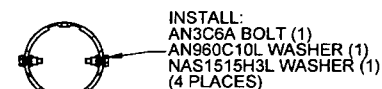
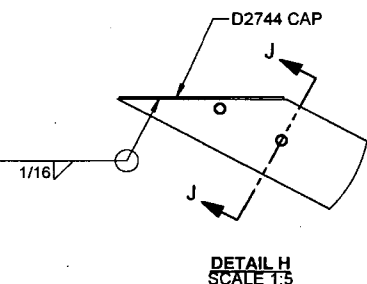
8 7 6 5 4 3 2 1

**D2750-043 ASSEMBLY (SHOWN)  
D2750-044 ASSEMBLY (OPPOSITE)**

BOND D2739 WEB INTO D2750-3 (OR D2750-4)  
OUTER TUBE WITH NON-STRUCTURAL  
SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.



**RELEASED**  
07-08-02



- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS AFTER FINISH

- WELDING INSTRUCTIONS**
- 1) CHAMFER HOLE 0.050 x 45°
  - 2) INSERT D2743 SPACER
  - 3) WELD INTO PLACE
  - 4) GRIND WELD FLUSH
  - 5) DRILL OUT SPACER TO Ø0.484
  - 6) SPOT FACE Ø0.750 (SECTION P-P ONLY)

DESIGN PH	DRAWN BY CB	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2750	REV. E SHEET 5 OF 5
DATE 07.05.17	TITLE 350 SKIDTUBE ASSEMBLY	SCALE 1:10	

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8 7 6 5 4 3 2 1

<b>DART</b>		TRANSPORT CANADA APPROVAL # 09-89		TEL: 1-613-632-3336		FAX: 1-613-632-4443	
P/N	D350-636-014	CHG	CHG002	MADE IN CANADA			
DESC	Skidtube Assembly	STC	SH99-7				
LOT	B33142	STC	SR00646SE				
MODEL	AS350/355	STC					
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING							